

Date: Thursday, 4/26/2007 7:48:17 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD  
 Job Number : 32071  
 Estimate Number : 12711  
 P.O. Number : N/A Part Number : D35373  
 This Issue : 4/26/2007 S.O. No. : N/A Drawing Number : D3537 UNDER REVIEW  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : ~~PH~~ PH 07.04.26  
 Previous Run : 31726 Material : C PH 07.05.23 10  
 Written By : Due Date : 5/3/2007 Qty: 20 Um: Each  
 Checked & Approved By : HA 07.04.26 28/05  
 Comment : Est Rev:A New Issue 07-02-14 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1512 sf(s)/Unit Total : 3.0240 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: m101813 ml 07 04 26 (20) 15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: B C ml 07 04 26 (20) (PWC)

Prog Rev: B C

2-Deburr if necessary 10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 07 04 26 (20) 15

4.0 QC8 SECOND CHECK / Parts were found on the water jet 07-05-23



Comment: SECOND CHECK 07-05-23

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3


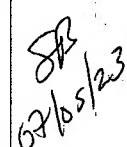
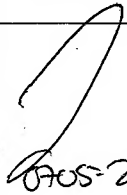
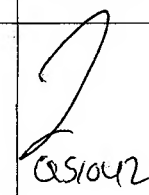
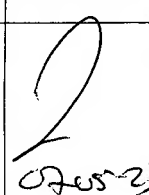
Form Joggle as per Dwg D3537 on brake using Jig DT8158 JB 07/06/01 10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0705-23	2.0	5pm4s done to old Rev. No good.	 051042	Scr API: destray. Qty 10 @ New Dwg Rev. C.	 07/05/23	 0705-23	 051042	 0705-23

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 32071

Part Number: D35373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

BD 07-06-01 (10)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R 2059B Hardcoat  
Weld hardcoat as per Dwg D3437

Batch  
M102956

FL 07/06/01 (10)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/01 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/01 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 101601

BR/FL 07-06-04 (10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/06/04 (10X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stook  
Location: EP-18

M-L 07/06/04 (10X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

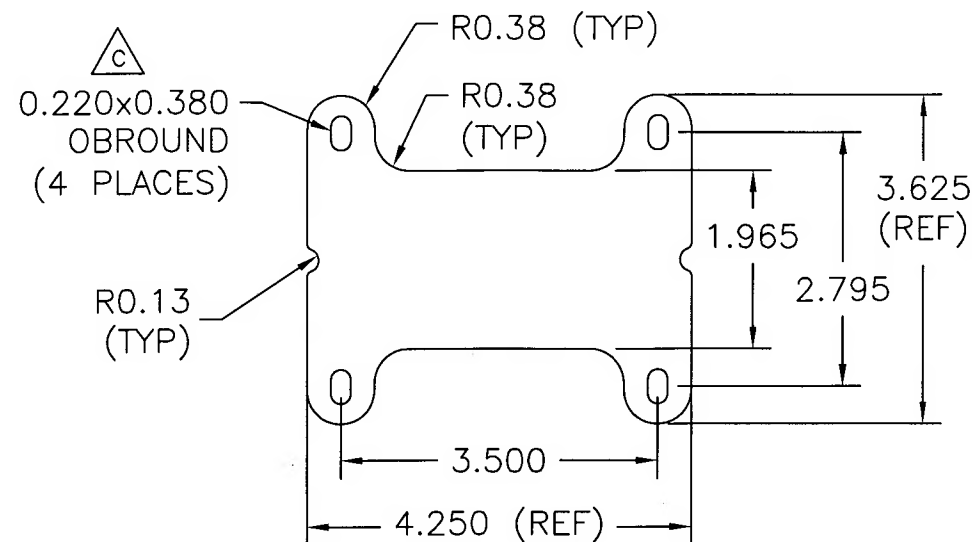
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

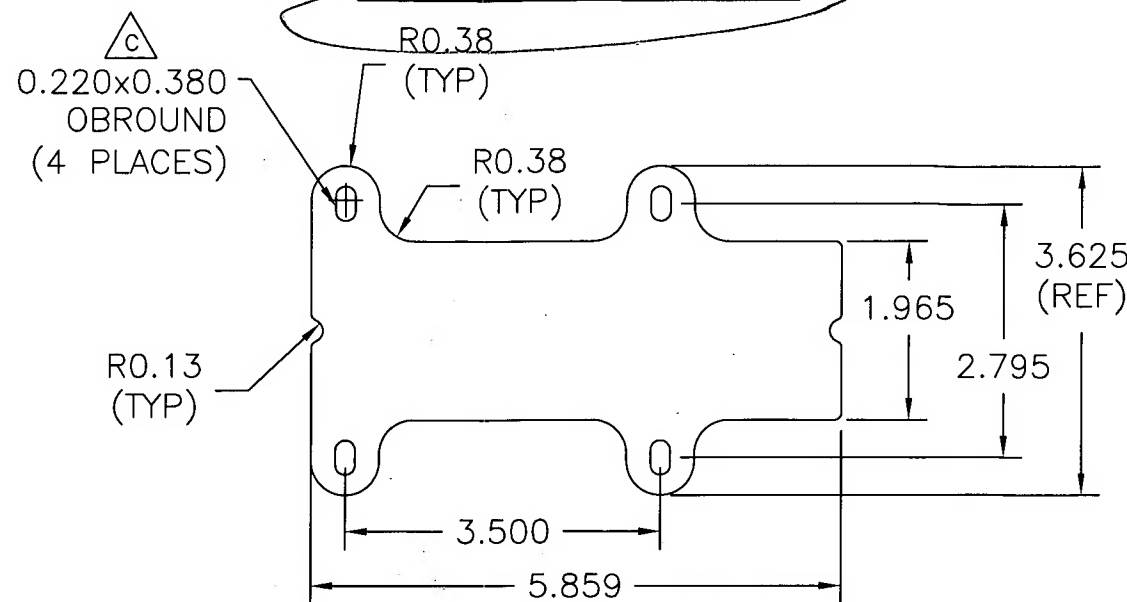
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

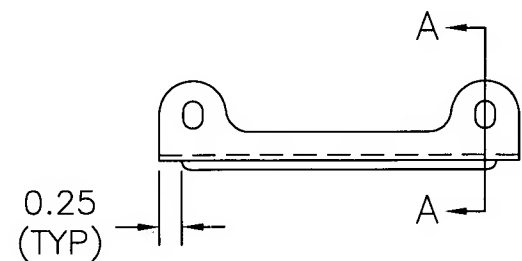
### D3537-1F FLAT PATTERN



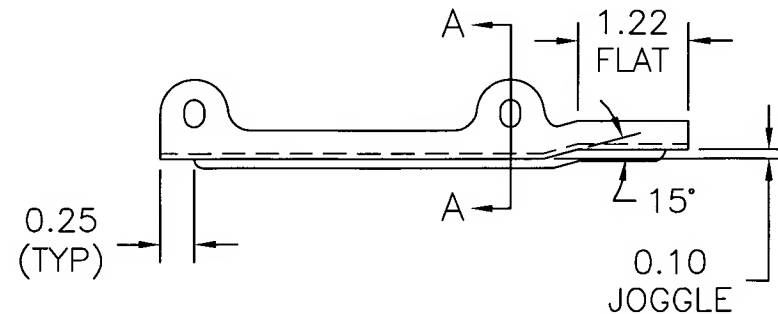
### D3537-3F FLAT PATTERN



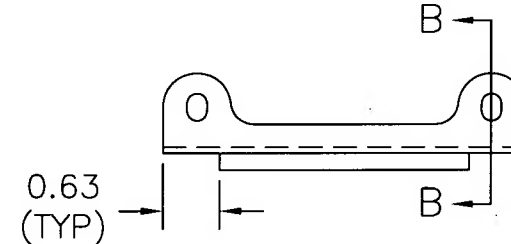
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



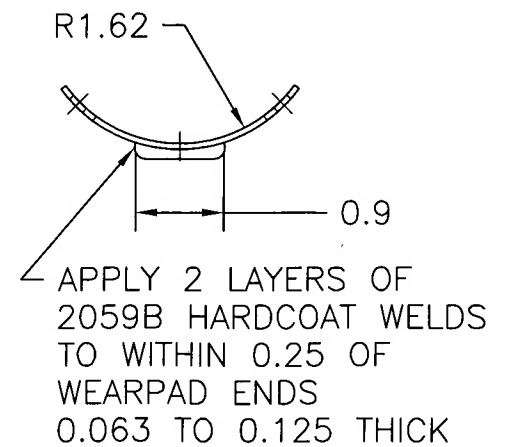
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



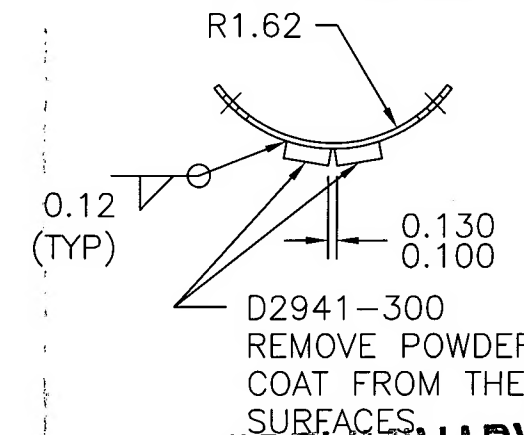
### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

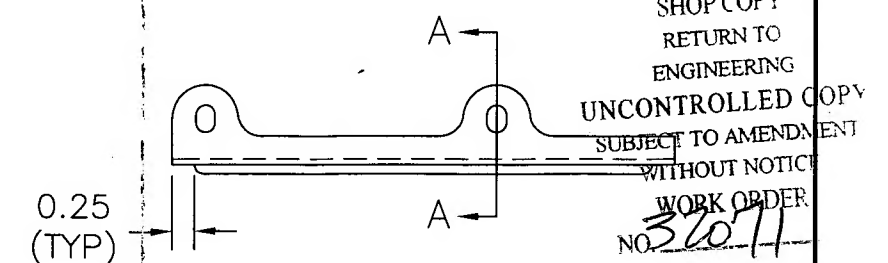
### SECTION A-A



### SECTION B-B



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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DESIGN	C B	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	07.04.13	DRAWING NO.	D3537	REV. C
		TITLE	WEARPAD	SHEET 1 OF 1
				SCALE 1:2



DART AEROSPACE LTD		Work Order: 32071
Description: Wearpad		Part Number: D3537-3
Inspection Dwg: D3537	Rev: B C PH 07.06.05	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.625	+/- 0.010	3.624	✓		VERN	
B 2.795	+/- 0.010	2.795	✓		VERN	
C 1.965	+/- 0.010	1.968	✓		VERN	
D 3.500	+/- 0.010	3.504	✓		VERN	
E 5.859	+/- 0.010	5.866	✓		VERN	
F 0.220 x 0.380	+/- 0.010	0.217 x 0.380	✓		VERN	
G						
H						
I						
J						
K						
L						
M						
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W						
X						
Y						

Measured by: <i>ML ML</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>NA</i>
Date: 07 04 26	Date: 07 05 23	Date: <i>NA</i>
Rev	Date	Change
		New Issue
	Revised by	Approved
	KJ/RF	